



Dart Hawkesbury
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D4635-144
Job Sheet 167086-A



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.16	HandFinish4	
110	Small Fab	1 pcs		11/10/17	0.00	1.57	Small Fab	
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-4 5022727	1	2	0	0
	D4669-1	1	27	0	0
	D4695-4 5024325	1	2	0	0
	D4732-11 5022726	1	5	0	0
	D4732-39 5022724	1	6	0	0
	D4732-41 5022723	1	6	0	0
	D5022-5 5126186	1	2	0	0

Part Specifications

Specifications could not be found.

Plex 10/24/17 11:07 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Susp ☐		Small Fab ☐	Prod. Eng. Coord. ☐	Rec/Store/Packaging Supplier ☐	Quality ☐
Date: _____		Step #: _____		Other ☐			
Description Work Order Dev		Job No: 167086-A Mfg Date: 12/22/17					
		Start up Operation					
		D4635-144					
		PART NO: _____					
		Revision: _____					
		Change No: _____					
		Operation: _____					
		Completed By _____					
		Lead hand / Supervisor Approval Verification _____					
		QC / QA Coordinator Approval _____					
		Art Ceiling Replacement Panel Assembly, RH					
		S026642					
		DART AEROSPACE					
		1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Root Cause							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Set-up ☐	Weld ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	BOM/Route ☐	Wrong Stock Pulled ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	Broken/Damage/Defect ☐	Out of Sequence ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Inspection Incomplete/Unqualified ☐	Off-set ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Contamination ☐	Mislabeled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Cut Too Short ☐	Fit/Function ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Drill Holes ☐		Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐			Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐			Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
		OTHER: _____					